120

QC4-100% Inspect kits for completeness

120 QC

Quality Control

Memo

												DQA:	Da	ite:	
NCR: Y	es /	/ No				WORK ORDER NON-O	O	NFOR	MANCE / UP	DATE		•			
												QA Closed:	Da	ite:	3
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		•
Work Orac						Rework	1		Skid-tube	Crosstube	Г	1	Water Jet	Γ	Engineering
Part N	No.					Scrap	1 1	1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is]	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	No					Work Order Update]		Large Fab	Composite]	Supplier		
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Root	- 1					ption of work order update	1	nitial		tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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Equip/Tooling	Ш														
Operator	Ш														
Material	Ш											į			
Setup	Щ														
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Process	Ш		·												
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Training															
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Landi	ng Ge	ar				General					_	_		_	-
	В	ending				Bend		Grain				Ovalized			Pressure/Forced
*	c	entre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	C	racks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	:t		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing Finish

99936

Work Order ID 99936 April-16-13 12:35:54 PM

Item ID:

Required Date: 4/30/13

646.4001

Accept

N900040100

Setup Start

Item Name: Start Date:

Revision ID:

4/16/13

Start Qty: 1.00 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

AS350 Cable Cutter

Date:

Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Tool # Plan

Code

Run Start

Stop

Sequence ID/ Work Center ID

130

130

Packaging

Packaging

Packaging

Operation

Description

0.00 Identify and pack for shipping as per PPP 646.4001

Location:

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Accept **Qty**

Reject Qty

Reject Insp. Number Stamp



12-05-30 MF 13-5-30

NICO.	V	,	81-
NCR:	Yes	1	No

DQA:

Date:

NCR: Y	es / I	ю				WORK ORDER NON-	CON	1FOKI	MANCE / UPI	DAIL		OA Classili	D-		3
						7	-					QA Closed:	Da	te:	
Work Orde	ŕ:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		•
						Rework]		Skid-tube	Crosstube			Water Jet	\vdash	Engineering
Part N	o					Scrap	↓ Ⅰ		Machining	Small Fab		l .	d. Eng. Coor.	-	Quality
						Use-as-is	↓		noforming	Finishing	$\overline{}$	Rec/Sto	re/Packaging		Other
NCR N	o					Work Order Update	J		Large Fab	Composite			Supplier	L.	
Root	1	\neg		 1	Descr	iption of work order update	1	nitial	Δct	tion		Sign &			
Cause	Da	اما	Step	Qty		or Non-conformance	l l	ief Eng		ription		Date	Verificatio	n	QC Inspector
oc/Data	1 50	+	Step	Qty		of Non-comormance	1	ici Liig	Desci	трион		Date	vermeatio	<u>:-</u> -	QC IIISPECTOI
quip/Tooling					:										
perator							ļ								
Material	7						Ì								
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						F	AUL	T CATE	GORY						
Landin	g Gear					General						-		_	
	Bend	ing			L	Bend	Ш	Grain				Ovalized			Pressure/Forced
	Cent	e Not	Concer	tric to	o/s	BOM/Route	Ш	Hardwa	re			Over/Under	tolerance		Temperature/Cure
Į	Cracl	s			L	Broken/Damaged	\vdash		on Incomplete			Part Incorred	ct		Weld
Ĺ	_		imped			Burrs	_		ions Incomplete/U	Jnclear		Part Lost/Mi	ssing		Wrong Stock Pulled
1	Cuffs					Contamination		Mainte	nance		_	Part Moved			
ļ	—	Treat			<u></u>	Countersink	-	Mislabe				Positioned V		_	1
·	_		Strip in	Tube		Cut Too Short	\vdash	Misread				Power Loss/	Surge		Other
	─ ' ' '	es in B			•	Drill Holes	-	Offset							
			ves in E	xtrusio	n	Drawing	\vdash		Calibration						<u> </u>
	_	-	quence		L	Finish	\vdash		equence				·		
- 1	Wav	/Twis	t in Tub	e		Folio		Outside	Dimensions					-7	

April-16-13 | 12/35:5" PM

Work Order ID: 99936

99936

· Parent Item:

646.4001

646 4001

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13

Required Date: 4/30/13

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:	IPP REV:A 12.10	.23 NEW ISSUE	DD	VERF:JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3301 646.3301 Copper Cutter Assembly	*	Manufactured	No	-		• ••	Each	25.0000	**	_		ĺ	
S	3mP			Location ST139A ST545	125083	<u>Loc Ç</u>	Pty 7 7 18	Loc Code			-		
*646.3001 *646.3001 llower Gutter-Assembly	<u>j*</u>	Manufactured	No	_	93247		18 Each	17.0000	**	3277	? 		20
57	P			ST537	125083	<u>Loc Q</u>	<u>ty</u> 9 9 8	Loc Code	_ _				
646.2910 *64/6 2910 Deflector	j*	Manufactured	No		93425		8 Each	6.0000	** 7	3423	2	a.	20 13/5/2N
	>M)			Location ST139A	125083	<u>Loc Q</u>	<u>ty</u> 6 6	Loc Code					,

											DQA:	Date:	
NCR: Ye	s / I	No				WORK ORDER NON-C	ON	FORM	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:	:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
						Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part No). [']					Scrap		ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			·			Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	D					Work Order Update]		Large Fab	Composite	J	Supplier	
Root	T				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Da	ite	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		,			-								
Equip/Tooling							1						
Operator	_						1				ļ		
Material													i

FAULT CATEGORY Landing Gear General Ovalized Pressure/Forced Bend Grain Bending Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Part Lost/Missing Wrong Stock Pulled Instructions Incomplete/Unclear Crushed/Crimped Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Misread Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Out of Sequence Finish Turning Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Setup Other Process Supplier Training Unapproved

Required Date: 4/30/13

Required Oty: 1.00

Start Date: 4/16/13

Start Qty: 1.00

**

125083

Loc Code

Picklist Print

April-16-13 12:35:57 PM

Work Order ID: -99936

646,4001

99936 *646 4001*

Parent Item Name: AS350 Cable Cutter

Parent Item:

646.3810 Manufactured Each 8.0000 Location Loc Qty Loc Code ST139A 93300 646.3510 Manufactured Each 3.0000 Location Loc Qty Loc Code ST139B 3 125083 3 646.3511 Manufactured No Each 2.0000 Location Loc Qty Loc Code ST 2 125023 2 646.3512 Manufactured No Each 1.0000 Location Loc Qty Loc Code ST139A 125083 Manufactured Each 24.0000

April-16-13 12:35:57 PM

Shop Packet Print

Loc Oty

24

24

Location

ST139A

125083

Page 2

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP	PDATE	QA Closed:	Date:	•
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	•
	· · · · · · · · · · · · · · · · · · ·		·	*	Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part No.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		•			Use-as-is	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No.					Work Order Update		Large Fab	Composite		Supplier	
									· · · · · · · · · · · · · · · · · · ·		
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											

Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bending Bend Grain BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Part Lost/Missing Wrong Stock Pulled Instructions Incomplete/Unclear Crushed/Crimped Burrs Cuffs Maintenance Part Moved Contamination Positioned Wrong Mislabeled Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Ripples in Bend **Drill Holes** Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Equip/Tooling
Operator
Material
Setup

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:57 PM

Work Order ID: 3/99936

Parent Item:

NAS1149F0332P

646.4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

Start Date: 4/16/13

8,710.000

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

MS21042L3

Purchased

Purchased

No

No

Location Loc Oty Loc Code GA 182 122063 182 ST294 158 122063 158 ST295 3 123352 3 st510 8367 123900 8367 Each 4,780.000

Each

<u>Location</u>	Loc Qty	Loc Code
FP001	3	
122141	3	
GA	119	
122452	. 119	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	4390	

974

3416

the state of the s

123900

124291

										DQA:	Date:	
NCR: Y	Yes / No				WORK ORDER NON-C	CON	NFOR	MANCE / UPI	DATE			
					T					QA Closed:	Date:	
Work Orde	er:				DISPOSITION	ı			AGAINST DE	PARTMENT	/PROCESS	•
Part N	No.				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ī	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								·				
					F/	AUL	T CATE	GORY				<u> </u>
Landi	ng Gear				General		ſ		_	٦		1
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	Heat Tr	eat		l	Countersink		Mislabe	eled	į	Positioned V	Vrong	•

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Required Date: 4/30/13

Picklist Print

April-16-13 12:35:57 PM

Work Order ID: 99936

646.4001

99936 *646 4001*

Parent Item Name: AS350 Cable Cutter

· Parent Item:

Required Qty: 1.00 646.3110 Manufactured Each 6.0000 Location Loc Qty Loc Code ST139A 125083 646.3710 Manufactured 22.0000 Each (eMB Location Loc Oty Loc Code ST425 22 97175 22 646.3210 Manufactured No Each 5.0000

	حرادات
646.3713	
646 Gusset	3713
Gusset	-4

Manufactured

Location Loc Qty Loc Code ST538 5 93488 5 Each 7.0000

Location	Loc Qty	Loc Code
ST139A	7	
93208	7	

Start Date: 4/16/13

Start Qty: 1.00

**

NCR: Ye	s / No

												DQA:	Date	:
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						_			•			QA Closed:	Date	· ·
Work Orde	i :					١	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N							Rework Scrap		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			-	Water Jet d. Éng. Coor.	Engineering Quality
, NCR N	o				······		Use-as-is Work Order Update		inern	Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root			· · · · ·		Desc	rip	tion of work order update		nitial	Acti	ion	Sign &		
Cause	D	ate	Step	Qty		o	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other rocess upplier raining					-									
napproved								<u> </u>	T CATE	CORY				
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Landin	Ber	ding	ot Concer	ntric to	o/s	$\overline{}$	General Bend BOM/Route	F	Grain Hardwa	re	F	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Cra	cks			Ī		Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct 🗍	Weld
	Crushed/Crimped Burrs								Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination						Contamination		Mainte	nance		Part Moved	•	
	Heat Treat Countersink						Countersink		Mislabe	eled		Positioned V	· -	_
	Ins	pection	n Strip in	Tube			Cut Too Short	Misread			L.	Power Loss/	Surge	Other
,	Rip	ples in	Bend		L		Drill Holes	Offset						
	Tor	que W	aves in E	xtrusio	n [Drawing	Ŀ	Out of 0	Calibration				
	Turning Sequence Finish Out of Sequence								Sequence					

Outside Dimensions

Wave/Twist in Tube

April-16-13 12:35:5" PM

Work Order ID: 99936

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

Location

116805 123741

ST303

Start Date: 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

MS24694-S51

Purchased

No

Each

108.0000

Loc Code

Purchased

No

Loc Oty 108 107

Each 95.0000

**

AN3-13A

AN3-4A

Purchased

No

Location Loc Qty Loc Code ST351 45 104746 15 120910 30 ST512 50 123759 50 Each 453.0000

**

Location Loc Oty Loc Code ST350 318 120308 80 122814 38 124858 200 ST512 135 120770 134 123900

											DQA	Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE	QA Closed	: Date	
						y					QA Closed	. Date	•
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	4
	٠				 	Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part I	No.					Scrap	1	!	Machining	Small Fab	Pro	od. Eng. Coor.	Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update]		Large Fab	Composite]	Supplier	
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Root					1	ption of work order update		Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Operator	Ш												
Material	Ш												
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Process			1										
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Training													
Unapproved			<u> </u>										
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Landi	ing (Gear				General					_	_	_
Bending						Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ect	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:57 PM

Work Order ID: 99936

646.4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

Location

123785

ST329

CR3213-5-3

Parent Item:

Purchased

No

Each

300.0000

Loc Code

Loc Code

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

Purchased

No

Loc Qty 300 300

Each 741.0000

Rivet

646.3711

Manufactured

646.3712 Manufactured

Location Loc Oty ST336 741 741

Each 2.0000

Loc Code

2 2 Each

2.0000

Loc Code

**

Location ST139B

Location

ST139B

125083

125083

Loc Oty 2

Loc Qty

										DQA:	Date:	
NCR: \	Yes / I	10			WORK ORDER NON-O	100	NFORM	MANCE / UPDATE				
										QA Closed:	Date	*
Work Orde	er.				DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS	•
Part N	No				Rework Skid-tube Crosstor Machining Small (Use-as-is Thermoforming Finish Composition) Work Order Update Large Fab Composition				III Fab		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	ı	nitial	Action		Sign &		
Cause	Da	te Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
Ţ.					<u></u> _	AUL	T CATE	GORY				
Landii	Bend Cent Cracl Crusl	re Not Conc ss ned/Crimpe		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		1	on Incomplete ions Incomplete/Unclear nance		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:57 PM

Work Order ID: \ 99936

·Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

646.3811

Manufactured

No

Each

29.0000

**

**

**

AN3-6A

Purchased No

Purchased

Location ST139A 125083 93224

Loc Code Loc Qty 29 20 Each 438.0000



Location Loc Qty ST350 300 124296 300 ST351 61 117441 34 121166 13 122993 10 123831 ST512 77 122814 77 Each Loc Code

92.0000

Screw

Location Loc Oty Loc Code ST303 92 124296 92

April-16-13 12:35:57 PM

Shop Packet Print

Page 7

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UPDATE		·		
									··-		QA Closed:	Date	:
Work Ord	۸÷۰					DISPOSITION			AGAINS	ST DE	PARTMENT	/PROCESS	
WORK Ord	er. -					Rework	1	,	Skid-tube Crosstul	ne[]	Water Jet	Engineering
Part I	No.					Scrap	1		Machining Small Fa	-	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1	1	noforming Finishi	<u> </u>	4	e/Packaging	Other
NCR I	No.					Work Order Update]		Large Fab Composi	te]	Supplier	
Root					Descri	L ption of work order update		Initial	Action		Sign &		
Cause	l	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling				' '	İ								
Operator							l						
Material													
Setup	П						ļ					ı	
Other													
Process	П		ļ]		İ		`				
Supplier													
Training													
Unapproved			<u> </u>										
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Landi	ng G	Gear				General		,					- ,
	Ш	Bending			·	Bend		Grain		\perp	Ovalized		Pressure/Forced
	Ш	Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
'		Cracks				Broken/Damaged		Inspecti	ion Incomplete	L	Part Incorred	it 🤞 📙	Weld
		Crushed/	Crimped			Burrs	Instructions Incomplete/Unclear				Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Treat					Countersink	Mislabeled				Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:5" PM

Work Order ID: +99936

646.4001

99936

Parent Item Name: AS350 Cable Cutter

Parent Item:

646 4001

Start Date: 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

646.3610

646.3714

Manufactured

Purchased

Manufactured

Each

18.0000

Loc Code

1,756.000

**

Manufactured

MS20470AD5-6

646.3812

Gusset Bracket

No

Location

ST336

Location Loc Qty 125083 125083 ST139A 11 93434 11

Each 2.0000

Location Loc Oty Loc Code ST139A 2

93175 2 Each

> Loc Qty Loc Code

. 1756 105433 124089 890

866 Each 9.0000

Location Loc Qty Loc Code ST139B

93185

										DQA:	Date	: , , ,		
NCR: Ye	es / No				WORK ORDER NON-	-COI	NFOR	MANCE / UPDATE						
		···								QA Closed:	Date	:		
Work Orde	ŕ:				DISPOSITION			AGAINST	T DEP	ARTMENT	/PROCESS	•		
Part N					Rework Scrap]	1	Skid-tube Crosstube Machining Small Fab noforming Finishing	Ņ		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR N	o			,	Use-as-is Work Order Update			Large Fab Composite	_	Rec/Stol	Supplier	Other		
Root				Descri	ption of work order update		Initial	Action		Sign &				
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector		
Doc/Data	a L													
quip/Tooling														
Operator						1								
Material												·		
Setup														
Other														
rocess						ŀ			İ					
Supplier						ŀ			- 1					
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Inapproved		l												
						FAUL	LT CATE	GORY						
Landin F				_	General	Γ	Grain			Ovalized	<u> </u>	Pressure/Forced		
}	Bending Centre No	- + C		o/s	Bend BOM/Route	-	Hardwa		\vdash	Ovalized Over/Under	+-lerenee	Temperature/Cure		
<u> </u>	Cracks	or conce	יונות נטי	^{0/3} -	Broken/Damaged	-	4	ine ion Incomplete	-	Part Incorrec	├	Weld		
ŀ		Crimped		<u> </u>	Burrs	\vdash	4 '	ions Incomplete/Unclear	\vdash	Part Lost/Mi	· ·	Wrong Stock Pulled		
Crushed/Crimped Burrs Cuffs Contamination							Mainte	·	\blacksquare	Part Moved	3311 L_	Twiong stock i diled		
<u> </u>	Heat Treat Countersink						Mislabe			Positioned V	Vrong .			
·	Inspectio		Tube	-	Cut Too Short	-	Misread		-	Power Loss/		Other		
F	Ripples in	-			Drill Holes		Offset		<u> </u>			· · · · · · · · · · · · · · · · · · ·		
<u> </u>	Torque W		Extrusio	h	Drawing		1	Calibration	-	-		·		
<u> </u>	Turning S				Finish		Out of 9	Sequence	-					
-	Wave/Tw				Folio		1	Dimensions	_		-			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:57 PM

Work Order ID: 99936

.Parent Item:

AN3-3A

646.3813

MS20470AD5-7

MS21047-3

646,4001

Parent Item Name: AS350 Cable Cutter

99936

646 4001

Location

ST350

Location

ST139d

Start Date: 4/16/13

Required Date: 4/30/13

Required Qty: 1.00

Start Qty: 1.00

268.0000

Loc Code

Loc Code

Each

Loc Qty

268

200

7



Manufactured

Purchased

No

124221 124552

123831

125083

61 Each 5.0000

Purchased

No

No

Loc Oty 5 5

Each

Loc Qty

445

75

50

320

Each 2,194.000



Location Loc Qty Loc Code Mezz 1384 2655 799 3011 585 ST336 810 123425 810

445.0000

**



NUT PLATE

Purchased

Location ST316 123268 123301 123522

Loc Code

123506

April-16-13 12:35:57 PM

Shop Packet Print

Page 9

Work Order: Part No.	NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
Part No. Scrap Use-as-is Work Order Update Skid-tube Crosstube Prod. Eng. Coor. Quality Other Cause Date Step Qty Description of work order update Cause Date Step Qty Description of work order update Chief Eng Description Date Verification QC Inspector Description Quality Qther Description Quality Qther									,		QA Closed:	Date:	
Part No. Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Use-as-is Work Order Update Use-as-is Use-as-is Use-as-is Work Order Update Use-as-is Use-as	Work Orde	er:				DISPOSITION	_			AGAINST DE	PARTMENT	/PROCESS	,
Cause Date Step Oty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Caup/Tooling Caup/Too				·	 	Scrap Use-as-is	Scrap Machining Small Finishi				4	Quality	
Doc/Data Equip/Tooling Operator	Root	Description of work order update Initial Action								Sign &			
Equip/Tooling Operator Material Operator Material Other Process Supplier Training Unapproved Bending Centre Not Concentric to O/S Cracks Broken/Damaged Cracks Cracks Cracks Broken/Damaged Cuffs Cuffs Cuffs Cuffs Countersink Heat Treat Countersink Heat Treat Inspection Strip in Tube Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Drawing Draw	Cause	Dat	e Step	Qty		or Non-conformance	Chief	Eng	Descr	iption	Date	Verification	QC Inspector
Operator Material Setup Other	Doc/Data												
Material Setup Other Oth	Equip/Tooling						1						
Setup Other Process Supplier Training Unapproved FAULT CATEGORY Landing Gear General Bending Bend General Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Countersink Mislabeled Positioned Wrong Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration	Operator		Ì										
Other Process Supplier Training Unapproved	Material												
Process Supplier Training Unapproved FAULT CATEGORY Landing Gear General Grain Ovalized Pressure/Forced Temperature/Cure Over/Under tolerance Temperature/Cure Over/Under tolerance Temperature/Cure Over/Under tolerance Part Incorrect Weld Weld Over/Under tolerance Part Incorrect Weld Over/Under tolerance Ov	Setup												
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Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration		<u> </u>					AULT (CATE	GORY		<u> </u>		
Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion BOM/Route Hardware Hardware Inspection Incomplete Inspection Incompl	Landi				_	7	\Box				1	r-	7
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration		 1	-		_,	≓	-			<u> </u>	4	<u> </u>	-i
Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration		_		entric to	^{0/S}	=	\vdash			<u> </u>	4	-	-
Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration		-		1	<u> </u>	-1	-	-		la close	-{		4
Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration		—								- Icieai	1	22111B	I wrong stock runed
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Ripples in Bend Drill Holes Offset Out of Calibration	ļ, ,	—		n Tuhe		=	\vdash			<u> </u>	4		Other
Torque Waves in Extrusion Drawing Out of Calibration	`			Tube	-		\vdash		1	L	1. 5446, 2033/		12
		— ' ' '		Extrusio	,	╡	\mathbf{H}		Calibration				
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Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:5" PM

Work Order ID: 99936

Parent Item:

CCR264SS3-02

AN3-5A

646.3715

Strut Doubler

646.4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

No

Start Date: 4/16/13

**

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

Each

740.0000

Purchased

Purchased

Location ST327 106578 123785

GA

ST350

~ST512

124259

Loc Oty 'Loc Code =

Each

Loc Qty

12

12

1,103.000

Manufactured No

Loc Code 122800 86 120 -117423 120 22 120187 22

875 75 800

12.0000

Location ST139B 93338

, 122416

Loc Code

April-16-13 12:35:57 PM

Shop Packet Print

Page 10

											DQA	i: Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE				
											QA Closed	l: Da	ate:	<u> </u>
Work Ord	eŕ.					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		•
i i i i i i i i i i i i i i i i i i i	٠					Rework	1		Skid-tube	Crosstube	1	Water Jet	t 🗀	Engineering
Part I	Vo.					Scrap	1		Machining Small Fab			od. Eng. Coor.	-	Quality
	•					Use-as-is	1		noforming	Finishing	4	ore/Packaging	_	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier		
	•						•							
Root					Descri	ption of work order update	1	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	n	QC Inspector
Doc/Data														
Equip/Tooling				İ			İ							
Operator														
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Setup														
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		Bending				Bend		Grain			Ovalized		<u> </u>	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route					· ·	oxdot	Hardwa			Over/Unde	r tolerance	<u>_</u>	Temperature/Cure
7	L	Cracks				Broken/Damaged	L	-i `	on Incomplete		Part Incorr			Weld
		Crushed/	Crimped			Burrs		4	ions Incomplete/	Unclear	Part Lost/N	•		Wrong Stock Pulled
		Cuffs	· .			Contamination		Mainte	nance		Part Move	d		
		Heat Trea	at `			Countersink		Mislabe	eled		Positioned	Wrong	_	•
		Inspectio	n Strip in	Tube		Cut Too Short	Misread Power Loss/Surge							Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:57 PM

Work Order ID: 99936.

646,4001

Parent Item Name: AS350 Cable Cutter

99936

646 4001

Start Date: 4/16/13

Start Qtv: 1.00

169.0000

Required Date: 4/30/13

Required Qty: 1.00

MS27039-1-12

646.3716

·Parent Item:

Purchased

No

Location Mezz

Location

125083

Location

100993

1.

Loc Qty Loc Code

169 169

Each

Each 4.0000

**

Gauge Bracket

No

No

125083

Loc Qty

813.0000

Loc Code

**

MS20426AD5-7

Purchased

Manufactured

Purchased

ST334 101340 Loc Oty Loc Code 813 813

Each

Each

76.0000

**

Loc Qty Location ST303 76 123900 124859 75

Loc Code

NCR: Y	es / No				WORK ORDER NON-C	CON	FOKN	VIANCE / UP	DAIE	QA Closed:	Date	•: •:
Work Orde	nr.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part N					Rework Scrap Use-as-is		Skid-tube Crosstube Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	In	itial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						ł						
Operator						1		-				
Material	_					1						
Setup												
Other												
Process						1						
Supplier `					•							
Training												
Unapproved		i				<u> </u>				<u> </u>	<u> </u>	
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	Bending			~/ ₅	Bend BOM/Route	\vdash	Grain		<u> </u>	Ovalized	+=l======	Pressure/Forced
-	Centre No	ot Concei	ntric to (⁻ -	BOM/Route	\mathbf{H}	Hardwa		-	Over/Under Part Incorre		Temperature/Cure Weld
}	Cracks	C-:	•	<u> </u>	Broken/Damaged Burrs	$\overline{}$	•	on Incomplete ions Incomplete/l		Part Lost/Mi)	Wrong Stock Pulled
*	Crushed/ Cuffs	Crimped		-	Contamination			ions incomplete/ inance	officiear	Part Moved	issuig [
}	Heat Trea		•	-	Countersink	\vdash	viainte Mislabe		-	Positioned V	Mrong	
}	Inspectio		Tuho		Cut Too Short	-	viisiabe Viisread			Power Loss/		Other
	Ripples in	-	Tube		Drill Holes	\mathbf{H}	viisi eau Offset	•	<u> </u>	Ti ower ross/	Juige [Totaler
	Torque V		vtrucio	, ⊢	Drawing			Calibration				
	Turning S			' ⊢	Finish	\vdash		Seauence				
	I I WI HILLER	CHUCILLE		,	prinijil	1 1	-u. 01 J	requeries				

Outside Dimensions

Date: ____

DQA:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:58 PM

Work Order ID: 199936

Parent Item:

646,4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13 Required Qty: 1.00

MS27039-1-21

Purchased

Purchased

Manufactured

No

No

No

MS27039-1-19

MS27039-1-20

Screw

646.3717

Purchased

No

Location

ST306

ST506

Location

Location

ST306

ST506

st510

_124326

124326

.122814

123522

124326

125083

Each 343.0000

Loc Code

Loc Oty

Loc Qty

Loc Qty

478

478

Each

Each

478.0000

Loc Code

848.0000

**

Loc Code

Each

2.0000

Location ST139B

Loc Qty

Loc Code

2

2

Shop Packet Print

NCR:	Yes	/	Nο

WORK ORDER NON-CONFORMANCE / UPDATE

Date:

DQA:

NCK. 1	es / N	,			WORK ORDER NON-	CONFC	KIVIAIVCE / OF		QA Closed:	Date	•			
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	•			
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality			
NCR N	o				Use-as-is Work Order Update	- Th	ermoforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other			
Root				Descr	iption of work order update	tion	Sign &		·					
Cause	Date	Step	Qty		or Non-conformance	Chief E	ing Descri	ription	Date	Verification	QC Inspector			
oc/Data quip/Tooling Operator														
Material	_													
etup	7													
ther	7													
rocess														
upplier														
raining		1							·					
napproved			<u> </u>	<u> </u>										
			 		<u> </u>	FAULT CA	TEGORY							
Landin	g Gear			_	General			_	i	_	7			
	Bendir	_			Bend	Gra		<u> </u>	Ovalized	<u></u>	Pressure/Forced			
1	_	Not Conce	ntric to	O/S	BOM/Route	\vdash	dware	⊢	Over/Under	}	Temperature/Cure			
1	Cracks			_	Broken/Damaged	`	ection Incomplete	 	Part Incorred		Weld			
1	_	d/Crimped		<u> </u>	Burrs	<u> </u>	ructions Incomplete/	Part Lost/Mi	ssing	Wrong Stock Pulled				
]	Cuffs				Contamination		intenance	<u> </u>	Part Moved					
	Heat T			 	Countersink		abeled	—	Positioned V		7			
ļ.	—	tion Strip ir	1 Tube	L	Cut Too Short	Mis			Power Loss/	Surge	Other			
1		in Bend		<u> </u>	Drill Holes	Offs				·				
1	-	Waves in		n	Drawing		of Calibration							
1		g Sequence			Finish	\vdash	of Sequence				·			
Wave/Twist in Tube Folio Outside Dimensions														

April-16-13 12:35:58 PM

Work Order: TD: 5,99936

Parent Item: 646.4001

Parent Item Name: AS350 Cable Cutter

99936 *646 4001*

Start Date: 4/16/13

Start Qty: 1.00

45.0000

Required Date: 4/30/13

Required Qty: 1.00

A

M

の生物。かりりめ Gustom Washer

646.3718

Sm)

Manufactured No

Manufactured

 Location
 Loc Otv
 Loc Code

 ST139A
 7

 125083
 7

 ST522
 38

 93365
 38

 Each
 24.0000

Each

93360

4

Doubler

MS27039-1-10

SMP

Purchased No

 Location
 Loc Oty
 Loc Code

 ST139B
 24

 125083
 24

 Each
 321.0000

1250

**

**

2

13/0/28

*M\$\$27089-1-108

Shy

Location Loc Oty Loc Code GA 100 120449 100 ST305 101 122815 124859 100 ST308 18 123522 18 ST506 102 124326 102

124326

SPC Y

											DQA:	Date:	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UI								PDATE					
						T					QA Closed	Date:	
Work Ord	eŕ:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part I	•					Scrap Ma			Skid-tube Machining	Crosstube Small Fab Finishing	-	Water Jet od. Eng. Coor. re/Packaging	Engineering Quality
NCR I	No.					Use-as-is Work Order Update	}	Thern	Other				
Root					Descri	ption of work order update		Initial	A	ction	Sign &		
Cause		Date	Step	Qty	[or Non-conformance	Ct	nief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													es.
Setup													
Other			•										
Process			İ										
Supplier													
Training					f							1	
Unapproved													
							AUI	LT CATE	GORY			···	
Landi	ng G	Gear			_	General		-			_		-
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route						L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
Cracks Broken/Damaged					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
Crushed/Crimped Burrs					Burrs	L	Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination	Maintenance				Part Moved		
		Heat Tre	at			Countersink	Mislabeled				Positioned \	Wrong	-
		Inspection Strip in Tube Cut Too Short Misread						Misread			Power Loss,	/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:58 PM

Work Order ID: 1899936

Parent Item:

AN3-11A

646,4001

Parent Item Name: AS350 Cable Cutter

Purchased

Purchased

Purchased

Purchased

99936 *646 4001*

Location

Location

Location

ST

125051

125051

ST

No

No

No

No

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Oty: 1.00

672.0000

600.0990

600.0991

Magnabond 6398 Part B (One 4 oz can)

600.1012

600 1019

Sealant (One 6 oz Semkit

Location Loc Qty Loc Code ST351 72 123525 72 ST512 600 115457 100 123352 200 123759 300

Each

Loc Oty

Each

Each 9.0000

**

**

Loc Code

9.0000

9.0000

Loc Code

**

Loc Code

25057

2000/

125051

Loc Oty

Loc Qty

9

Each

											DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE			•
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	٠	
Part N	_					Rework Scrap			Skid-tube Aachining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo					Use-as-is Work Order Update			Rec/Store/Packaging Supplier		Other		
Root					Descri	iption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other crocess upplier training													
Inapproved							FΔIII	T CATE	GORY				
Landiı	ng Go	ear				General		LI CATE					ġ
		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in Torque W	Crimped t n Strip in Bend 'aves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/ nance led I	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	l 1.	Turning Se	equence			Finish	1	IOut of S	equence				

Outside Dimensions

Wave/Twist in Tube

April-16-13 12:35:58 PM

Work Order ID: 3 (99936)

Parent Item:

646.4001

99936

Parent Item Name: AS350 Cable Cutter

646 4001

600.0129

600.1013

Shim

Purchased

Purchased

No

No

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

Location ST 125031 Loc Qty 128 128

f

945.0000

Loc Code

**

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Loc Code

128.0000

646.3910

Manufactured

Location ST139A

125154

Loc Qty 945

945 Each

Each

72.0000

125154

Manufactured

Location Loc Qty Loc Code ST139B 22 125083 22 ST139d 50

93238 50

Each 20.0000

Loc Code

Location Loc Qty ST139A 125083 ST139d 19 93362 19

												DQA:	Da	te:	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	:01	NFORM	MANCE / UP	DATE					•
											_	QA Closed:	Da	te:	
Work Orde	>r.					DISPOSITION				AGAINST D	ΕI	PARTMENT	PROCESS		
Part N	-			·		Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing]		Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	No					Work Order Update			Large Fab	Composite]		Supplier		
Root					Descri	ption of work order update		Initial	Act	tion	7	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n ·	QC Inspector
Doc/Data															
Equip/Tooling							1								
Operator					·						-				
Material					,						-				
Setup									<u> </u>		1				
Other											-				
Process									1						
Supplier											١				
Training															
Unapproved								_							
						F/	AUL	LT CATE	GORY		_				
Landi	ng G	iear				General		_		_	_	•	•		•
		Bending				Bend	L	Grain		<u> </u>		Ovalized		L	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire	_	╛	Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	ion Incomplete		╝	Part Incorred	ct .	L_	Weld
		Crushed/	Crimped			Burrs	L	Instruct	tions Incomplete/	Unclear		Part Lost/Mi	ssing	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance			Part Moved			
		Heat Trea	t			Countersink		Mislabe	eled			Positioned V	Vrong	_	-
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d			Power Loss/:	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:58 PA1

Work Order ID: 299936

646.4001

99936 *646 4001*

Parent Item Name: AS350 Cable Cutter

'Parent Item:

646.3912

Manufactured

Manufactured

Purchased

No

Start Date: 4/16/13

**

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73.0000

Required Date: 4/30/13

Start Qty: 1.00

Required Qty 1.00

Location ST139A 125083 ST139d 93423

Loc Qty Loc Code 22 22 51 51 Each 36.0000

Each

646.3913

Location Loc Qty Loc Code ST139B 16 125083 16 ST139d 20 93160 20 Each 59.0000

123759

Location Loc Qty Loc Code GA: 122407 ST351 5 114536 123352 ST512 48 123759 48

April-16-13 12:35:58 PM

Shop Packet Print

Page 16

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
									-		QA Closed:	Da	te:
Work Ord	er: _					DISPOSITION	7		داننا دد.	AGAINST DE	PARTMENT,	/PROCESS Water Jet	
Part I	-					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	d. Eng. Coor. e/Packaging Supplier	Quality Other
Root				<u> </u>	Descri	ption of work order update	T	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng		iption	Date	Verificatio	n QC Inspector
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Equip/Tooling	П								,				
Operator	П								,				
Material	П												
Setup	П												
Other	П			1									
Process	П												
Supplier	П												
Training	П												
Unapproved	П												
,		٠				F	AUI	T CATE	GORY				
Landi	ng G	iear	•			General		_			-		,
:	Ш	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	<u></u>	Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorred	ct _	Weld
		Crushed/	Crimped			Burrs	\perp	instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
	Ш	Heat Trea	it			Countersink	L	Mislabe	eled		Positioned V	· ·	
	\square	Inspectio	n Strip in	Tube		Cut Too Short	<u></u>	Misread	i	L	Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					1.
		Torque W	aves in 8	Extrusio	n	Drawing	1.	Out of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence
Wave/Twist in Tube

Finish

April-16-13 12.35:58 PM

Work Order ID: 99936

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

99936

646 4001

Start Date: 4/16/13

Start Qty: 1.00

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70.0000

Loc Code

Required Date: 4/30/13

Required Qty: 1.00

MS27039-1-16

Purchased

No

Location ST306

122993

Loc Oty

70 70

Each

122993

												DQA:	Da	ite:	
NCR: Y	'es	/ No				WORK ORDER NON-C	:O1	NFORM	MANCE / UP	DATE		_			
						· · · · · · · · · · · · · · · · · · ·					Q	(A Closed:	Da	ite:	
Work Orde	sř.					DISPOSITION				AGAINST DI	EP#	ARTMENT/	PROCESS		
WOIR Old	-''-					Rework			Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	١о.					Scrap		1	Machining	Small Fab		Proc	d. Eng. Coor.		Quality
	-					Use-as-is		Thern	noforming	Finishing]	Rec/Stor	e/Packaging		Other
NCR N	lo.					Work Order Update			Large Fab	Composite	_		Supplier	L_	
				r	,						_	s: 6 I			
Root		_	_	_	1	ption of work order update		Initial		tion		Sign &			06 (
Cause		Date	Step	Qty	- (or Non-conformance	Ch	ief Eng	Desc	ription	╀	Date	Verificatio	<u>n</u>	QC Inspector
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							AUL	T CATE	GORY				·····		
Landi	ng G	iear			_	General		7			7				1
	—	Bending				Bend	⊢	Grain			-1	valized	•	\vdash	Pressure/Forced
		Centre No	ot Conce	ntric to	O/S	BOM/Route	∟	Hardwa			–i	over/Under		⊢	Temperature/Cure
	Щ	Cracks				Broken/Damaged	$ldsymbol{f eta}$	4 .	ion Incomplete	<u></u>	-	art Incorrec		\vdash	Weld
	Ш	Crushed/	Crimped			Burrs	L	4	ions Incomplete/	Unclear	-	art Lost/Mis	ssing	$ldsymbol{le}}}}}}$	Wrong Stock Pulled
	ot	Cuffs				Contamination	_	Mainte	enance		-1	art Moved			
		Heat Trea	it			Countersink	$ldsymbol{f L}$	Mislabe	eled		-	ositioned W	•	_	7
		Inspection	n Strip in	Tube		Cut Too Short	l	Misread	d		JP	ower Loss/S	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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	ENGINEERING CHANGE N	DTICE NO	03079	SHE	ET 1 Lif 1
APICAL	DWG NO. 646.4000	REV: A PI	REPARED N.CAP	DATE: 03/21/11	EFFECT IN DWG
INDUSTRIES, INC.	DWG TITLE: AS350 CAB	LE CUTTERS	News	<i>y</i> *,.	<u> </u>
	APPROVED BY: ENGR	MFG Savo	x Barbon ac/les	ourbline Effi	NEXT ORDER
TRANSACTION CODES (TC); A-ADD C-CREATE R-REVISE D-DELETE	REASON CREATED FIXED) AND CCK W			
SHEET 1,	2.11 1	9936 MLJ 13-04-16	1	32 646.3813 STRUT BRACKET 31 6012822 BRLY 32 646.3812 GISSET BRACKET 29 6012564 RIVET 28 646.3714 GISSET 26 646.3714 GISSET 26 646.3810 FILLER 26 6012830 SCREV 27 646.3811 RADIUS BLOCK 23 646.3712 CLIP 24 646.3711 CLIP 25 6012825 BILT 26 6012830 RIVET 20 6012827 BILT 21 6012832 RIVET 20 6012827 BILT 21 6012827 BILT 22 646.3710 GUSSET 23 646.3710 GUSSET 24 646.3710 GUSSET 25 646.3710 GUSSET 26 6012827 BILT 27 6012812 SCREV 28 6012827 BILT 29 6012823 BILT 20 6012827 BILT 20 6012821 SCREV 20 6012821 SCREV 20 6012821 SCREV 20 6012821 GUSSET 21 6012812 CUSSET 21 6012812 CUSSET 21 6012812 CUSSET 22 601624 LIDCONIT	MS2-1039-1-151 MS2-7039-1-151 MS2-7039-1-151 MS2-7039-1-151 MS2-7039-1-151 MS2-7039-1-151 MS2-7039-1-20 MS2-7039-1

REF	REF	ΠT	TREF	65	647.5701	GPS MOUNT KIT	77\	
		4		64	601.3151	VASHER	MEZICETOLY	
		3	L	63	601.2911	SCREV	XS24694833	
	1 2	7	15	62	601.2637	SCREV	MS27839-1-16	**************************************
	1 5	\Box	2	61	601.2763	BOLT	ANG-12A	***************************************
		7		60	646.3913	SHIM		
	4		4	59	646.3912	SHIM		***************************************
		\mathcal{L}		58_	646.3911	SHIM		***************************************
	4		4	57	646.3910	SHIDM		
	5	<	5	56	600.1013	PRIMER		
	8 FT		8 FT	55	600,0129	TVHB TAPE		
		\mathbf{N}		54	600.1012	SEALANT	FR-1425 CLASS 3	
,480H	A803	ADR:	400	FIND #	PART	DESCRIPTION	PIAN	SPE

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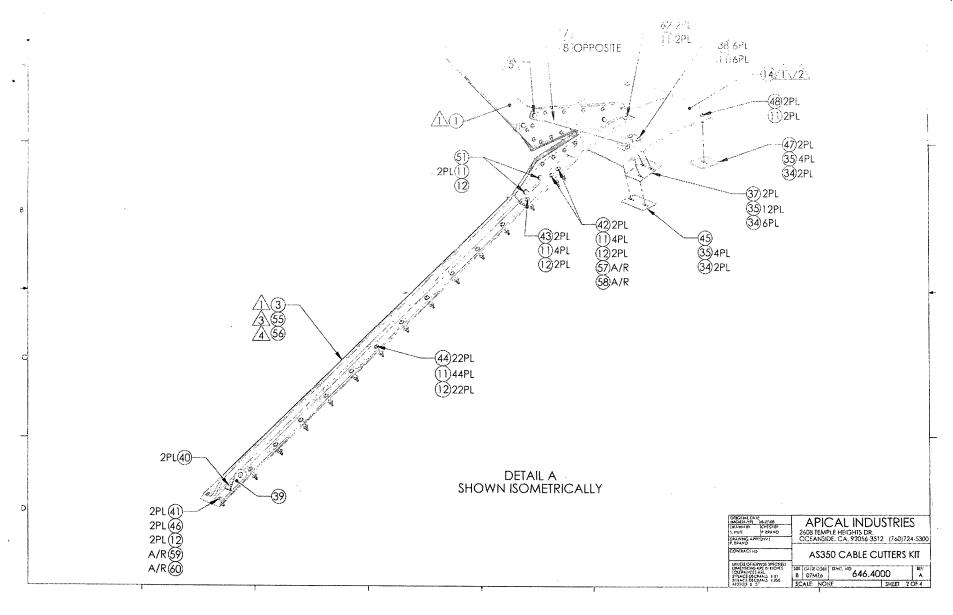
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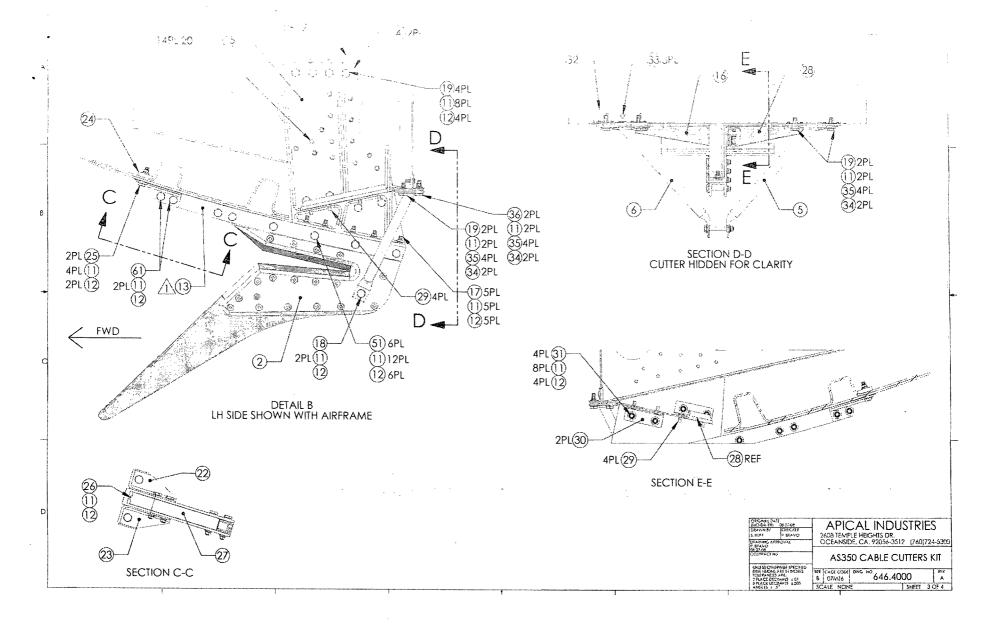
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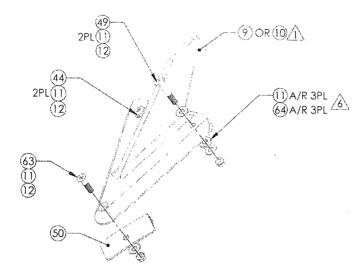
ENGINEERING CHANGE NUTICE NO. 03046	. (SHEET 1 OF 1
APICAI DWG NO. 646.4000 REV: A PREPARED JACKSE	DATE: 01/24	4/11 EFFECT ON DWG
INDUSTRIES INC DWG TITLE: AS350 CABLE CUTTERS KIT		
APPROVED BY: ENGR Brance MFG Davy Parker OC	Moune Lan-	EFF: NEXT ORDER
TRANSACTION CODES (TC): REASON: ADDED GPS MOUNT KIT, F/N 65. REVISED DRA A-ADD C-CREATE ADDED NOTE/7.	WING VIEWS!	
DETAIL D BOPPOSITE REF 1 TYPICAL GPS MODE TY	REF 65 A 1	
65 A 647.5701 REF GPS MOUNT KIT	<u>A</u>	
TIN IC PART NUMBER OTY	MATERIAL CATEGORY DER RE	SPECIFICATION VIEW REQUIRED
DOCUMENTS EFFECTED: MDL	R MINOR DE Y	

SW. NONES TO AFFER INSTALLATION, APPLY FIRE 54 A/R TO FILE GAPS AND FILLET EDGES 55 630 012 2 246 1417 223 INSTALL F/N 14 WITH F/N 52 8 53 MAL . 2 H . 65 1 52 600,0690 8 51 601,2826 3M VHB ADHESIVE TAPE .025 THICK X .50" WIDE VENDOR: MCMASTER-CARR P/N 75935A651 BOLI WPER BRACKE 50 645,3814 49 601,2910 SCREW 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE VENDOR: R.S. HUGHES P/N 021200-24216 2 48 601.1365 SCREW 47 546.3719 DOUBLEP CUSIOM WASHEI DOUBLER SCREW 46 646.3718 25 REUSE FASTENERS FROM F/N 1 1 45 646.3717 22 44 601.1948 2 43 601.1952 2 22 44 2 43 M53 #139-1 (9 USE WASHERS AS REQUIRED AS SHIMS TO OBTAIN BEST FITMENT MS02039 1-03 2 40 601.2829 2 40 601.2831 1 39 646.3716 SCREW 44227G39-1-01 SCREW RIVET M\$204284.D5 7 GAUGE BRACKET 1 39 646.3716 6 38 691.1953 2 37 646.3715 2 36 691.2824 36 35 601.2277 18 34 600.0795 3 33 601.2565 SCREW MS27039-1-1 STRUT DOUBLE BOL! RIVET A143-5A CC226457-34.0 33 601.2565 RIVET A1520470AD5 1 32 646 3813 4 31 601 2822 2 30 646 3812 6 29 601 2564 1 28 646 3714 DETAIL A AN3-3A GUSSET BRACKET RIVET GUSSET MS:0470ADS-6 1 27 646,3610 1 26 601,2830 1 26 601,2830 2 25 601,2825 1 24 646,3811 1 23 646,3712 DETAIL C SCREW M52-694955 BOLL At13.6A RADIUS BLOCK 22 646,3711 21 601,2832 CUP RIVE 5.5284704045.5 14 20 601,2020 19 601,2823 RIVET CR3213-5-3 10 BOLT AN3-4A 601,282 BOLT AN3-15A 646.4002-SCREW GUSSET 1A524694551 16 646.3713 1 15 646.3210 1 14 646.3210 1 13 646.3110 6 63 12 601.1624 SUPPORT 646.4001 646.3110 601.1624 CHANNEL LOCKNUT M\$21042(3 16 i34 11 601.1607 1 10 646.3411 1 9 646.3410 1 8 646.3513 WASHER NAS:149802375 RH WIPER DEFLECTOR -DETAIL B LH WIPER DEFLECTOR 646.3512 STRUT 646.3511 STRUT 601,3151 WASHER MACH 149503639 646.3510 63 601.2911 SCREW M\$24694553 BRACK 4 646.381 62 601.2637 SCREW MS27037-1-16 3 646,2910 DEFLECTOR 61 601.2763 BOLT ANS (2A) LOWER CUTTER ASSY 2 646,3001 60 646,3913 SHIM 646.3301 UPPER CUITER ASSY 59 646,3912 58 646,3911 SHIM 646.4002 ASSEST WIPER DEFECTOR OF SHIM A\$350 CABLE CUFFERS KIT MATL SPEC. MATIL SPEC. .oz su: FIND # PART# DESCRIPTION QTY PARTS LIST APICAL INDUSTRIES ORIGINAL DATE
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INDOTAT NEXT ASSY (S) 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 AS350 CABLE CUTTERS KIT SEE CARRECODE BING NO B 074426 646,4000 SHEET 1 OF 4 SCALE NON

2 .







DETAIL C LH SHOWN EXPLODED RH OPPOSITE

ORDMALDATE INCOCATES OF COLUMN DRAWNER OF COLUMN S.HEF SEAVO	APICAL INI 2608 TEMPLE HEIGHTS D OCEANSIDE, CA. 92056	OR.
COMPACT No.	AS350 CABLE	CUTTERS KIT
UNITS ONE PRISE SPECIFED DIVINGONS ARE PUBLIFES TO LEPANCES APE: 2 PLACE DECREASES 1.07 1 PLACE DECREASES 2.03	8 07MZ6 000 NO NO 646	.4000 REV
ANGUES ± 5	SCALE NONE	SHEE! 4 Of 4

n

Item ID: 646.4001 Accept Revision ID: Item Name: AS350 Cable Cutter Start Date: 4/16/13 Start Qty: 1.00 *1* Required Date: 4/30/13 Req'd Qty: 1.00 *1* Reference: Approvals: Process Plan: MLJ Date: 13-04-16 Tooling: QC: Date: SPC (Y/N): Sequence ID/ Operation Work Center ID Set Up/ Description **Run Hours** Draw Nbr Revision Nbr 646.4000 100 0.00 *100* DOCUMENT CONTROL Memo 0.00Document Control Photocopy bluefile & type labels per PPP 646.4001 110 Pick Kit 0.00 *110* Packaging Memo 0.00 Packaging 120 QC4-100% Inspect kits for completeness 0.00 *120* Memo 0.00 Quality Control

N900040100 Setup Start Stop Cust Item ID: Customer: Run Start Date: Stop Date: Tool ID Tool# Plan Accept Reject Reject Insp. Code Qty Qty Number Stamp MLJ 13-04-76